



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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D3121-141
Job Sheet 184328



Part No: D3121-141

Job Qty: 1 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/5/18

Job Tracking No:

Due Date: 10/31/18

Created By: Jason Leroux

Type: Stock

Description:

Note: DWG REV E IPP Rev:Pick:A 04.02.18 New issue KJ/DS IPP Rev:B ECN 1060 07-11-12 DD verified by: EC
IPP Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/31/18	10/31/18	0.00	0.00	Start Up Machining-1		SBL 18/10/05
100	Bandsaw	1 pcs	10/31/18	10/31/18	0.00	0.11	Bandsaw1		SBL 18/10/05
110	CNC Vertical Machining	1 pcs	10/31/18	10/31/18	0.47	1.96	HAAS1-3		SBL 18/10/05
120	QC	1 pcs	10/31/18	10/31/18	0.00	0.00	QC2 Machining-1		
130	QC	1 pcs	10/31/18	10/31/18	0.00	0.00	QC8 Machining-1		
140	Small Fab	1 pcs	10/31/18	10/31/18	0.00	0.03	Small Fab-2		
150	QC	1 pcs	10/31/18	10/31/18	0.00	0.00	QC5		
160	Packaging	1 pcs	10/31/18	10/31/18	0.00	0.00	Packaging3-1		
170	QC21-SA	1 Ea	10/31/18	10/31/18	0.00	0.00	QC21		

Part Op 100 - Cut blanks: (1.250" x 2.000") 6.600" long
Descriptions: 110 - 1-Machine D3121-111 as per Folio FA361 and Dwg D3121 Identify as D3121-111 3-Scribe batch number
140 - Assemble D3121-141 as per Dwg D3121.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.250X2.000	17-4 SS Bar 1.250 x 2.00	.5500 ft (.55 ea)	90-Start up Operation	5088987
D3121-21	Bolt	1 Ea (1 ea)	140-Small Fab	
D3121-241	Bearing Assembly	1 Ea (1 ea)	140-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-B1.250X2.000	1	4	0
140-Small Fab	D3121-21	1	59	0
	D3121-241	1	27	0

Part Specifications

Specifications could not be found.

Plex 10/5/18 1:49 PM dart.leroux.jason



Container No: S116314



Part: D3121-141

Job No: 184328

Serial No/Batch: S116314

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/05/18

0.19

DQA:

Date:

18/10/05

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only ☐

Work Order: <u>184 328</u> Part No. <u>D3121-141</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Date: <u>18/10/05</u>		Step #: <u>110 CMC. vert. machining</u>		QTY Effective: <u>1</u>		MRB (QSI042) Approval <u>18-10-05</u>																																																																	
Description Work Order Deviation <i>Spigot should have a diam. of 0,392^{+0,002}_{-0,000}</i> <i>Spigot was over tolerance so I took a free pass on it but the piece have move so now the spigot is oval</i>				Disposition <i>Scrap destroy</i>		Completed By DAS 9 9-89 <u>18-10-05</u> Lead hand / Supervisor Approval Verification <u>18/10/05</u> QC / QA Coordinator Approval <u>18-10-05</u>																																																																	
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